

Date: Thursday, 4/12/2007 8:41:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 31683
 Estimate Number : 12437
 P.O. Number : N/A
 This Issue : 4/12/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 29618
 Written By : JA 07.04.12
 Checked & Approved By : JA 07.04.12
 Comment : Est Rev: A New Issue 06-11-20 JLM

Drawing Name : STRUT
 Part Number : D35181
 Drawing Number : D3518 PRELIMINARY B
 Project Number : N/A
 Drawing Revision : A PRELIMINARY B
 Material : N/A
 Due Date : 4/20/2007

DWG WAS RELEASED
 @ REV. B ON 06.11.17

PLEASE
 UPDATE

07.04.12

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6-H0875 6061-T6 7/8" HexBar



Comment: Qty.: 1.1550 f(s)/Unit Total : 23.1000 f(s)
 6061-T6 7/8" HexBar
 Batch: M104182 M102838

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
 Turn as per Dwg D3518,

1-Face to Length and Drill & Tap.

M8 07/05/03 20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 07/05/03 20

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Drill as per Dwg D3518.

1-Drill 2x .191" holes & 1x .0625" hole

M8 07/05/04 20

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 07/05/04 20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/05/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng. | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 31683

Part Number: D35181

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

AK 07/05/08 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FH 07/05/09 (20)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/05/09

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EF 07/05/10 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EF 07/05/10 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ED 07/05/11

Job Completion



U 07/05/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

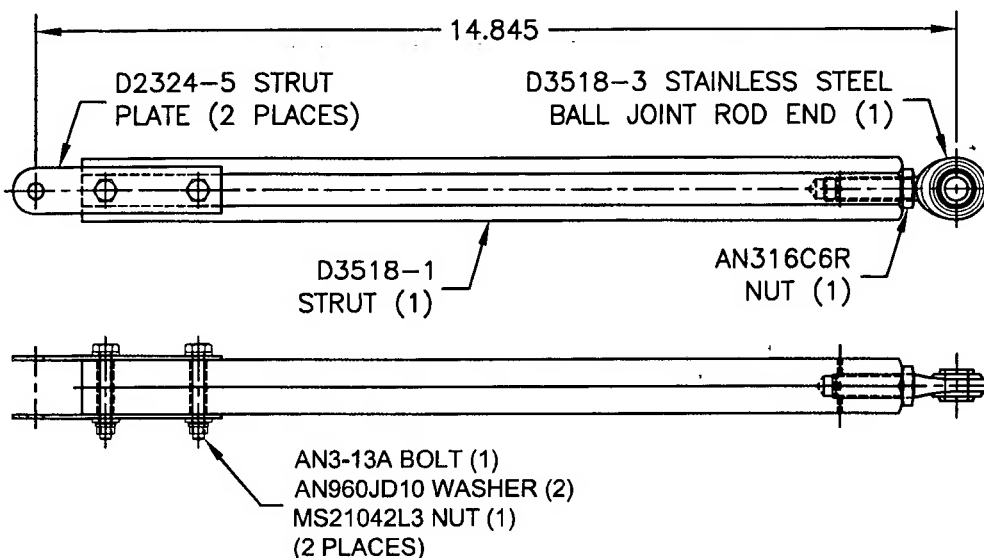
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 1 OF 3 |
| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:3 |
| A | 06.06.21 | NEW ISSUE | |
| B | 06.10.23 | RE-DESIGN | |

**D3518-041 STRUT ASSEMBLY**

| QTY -041 | Part Number | Description |
|-------------|-------------|------------------------------------|
| X | D3518-041 | STRUT ASSEMBLY |
| 2 | D2324-5 | STRUT PLATE |
| 1 | D3518-1 | STRUT |
| 1 | D3518-3 | STAINLESS STEEL BALL JOINT ROD END |
| 2 | AN3-13A | BOLT |
| 1 | AN316C6R | NUT |
| 4 | AN960JD10 | WASHER |
| 2 | MS21042L3 | NUT |

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WITHOUT NOTICE
WORK ORDER
NO. 31683

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

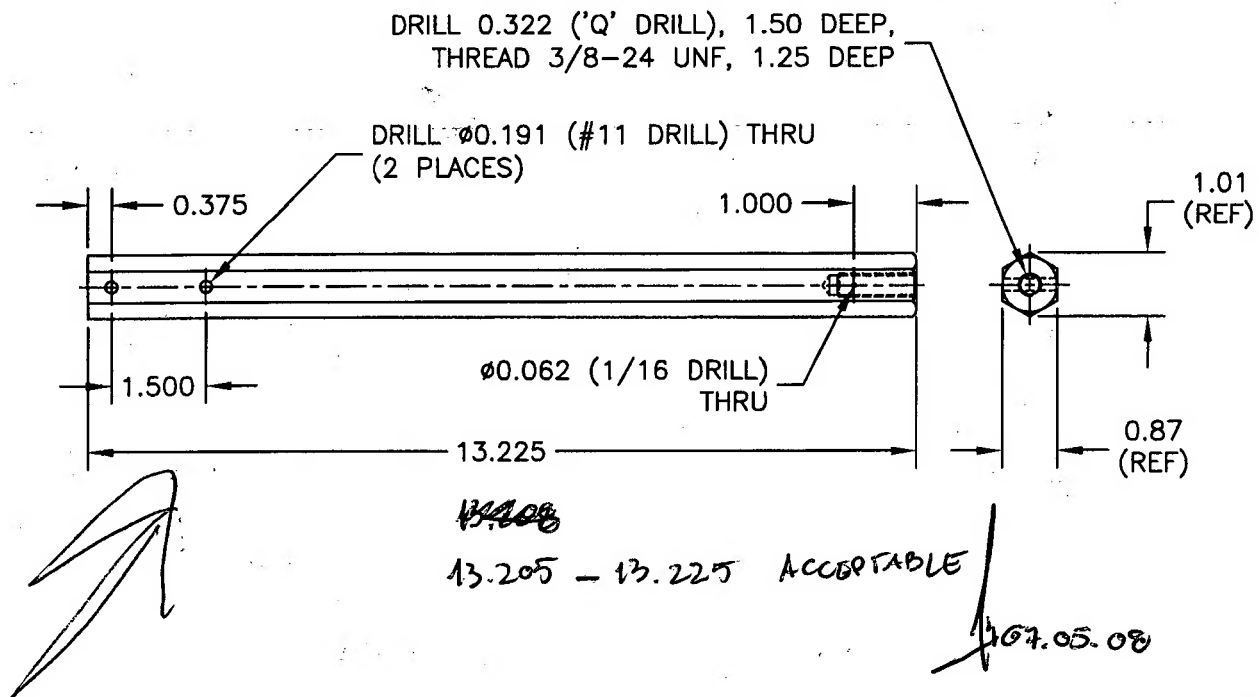
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DART

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|----------------------|--------------------------------|---|------------------------|
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| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 2 OF 3 |
| DATE 06.10.23 | TITLE BASKET (A119) STRUT | | SCALE 1:3 |

**D3518-1 STRUT****NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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NO. *31683*

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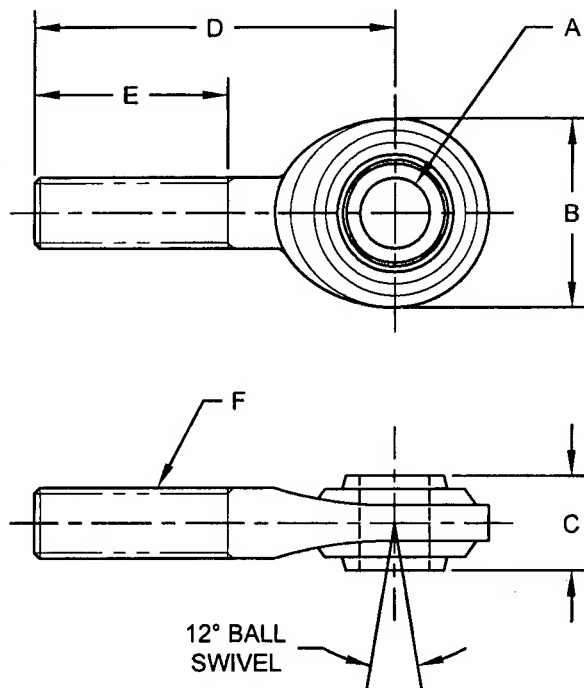
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| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:1 |

SPECIFICATION CONTROL DRAWING



| DART P/N | A | B | C | D | E | F | LOAD* | POSSIBLE SUPPLIER |
|----------|-------|------|------|-------|------|-------------------|-------|-------------------------------|
| D3518-3 | 0.375 | 1.00 | 0.50 | 1.938 | 1.25 | 3/8-24 UNF, RH | 4012 | McMASTER-CARR, P/N 2458K14 |

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED ELASTOMER BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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| | | |
|---|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 31683 |
| Description: Strut | Part Number: | D3518-1 |
| Inspection Dwg: 3518 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

| | | |
|-----------------|---|---------------------|
| Measured by: MS | Audited by:  | Prototype Approval: |
| Date: 07/05/03 | Date: 07/05/03 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

